

Work Order ID 81953

81953

March-21-12 1:39:02 PM

Item ID: D2652 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bushing
Start Date: 21/03/2012 Start Qty: 200.00 *200* Cust Item ID:
Required Date: 04/04/2012 Req'd Qty: 200.00 *200* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12/03/21 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2652	Rev A								

100 Hardinge CNC LATHE SMALL 0.00
100
Hardinge Memo 0.00 29 12-4-22 200 4
Hardinge CNC Lathe Small 1-TURN AS PER FOLIO FA252 & DWG D2652FOLIO
REV: 1/1 DWG REV: 1/1 2-DEBURR AS REQUIRED

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
QC Memo 0.00 29 12-4-22 200 4
Quality Control

120 QC8- Inspect parts - second check 0.00
120
QC Memo 0.00 29 12/04/23
Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81953

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N900040100

Setup Start *NS1*

Stop *NS2*

200

Cust Item ID:

200

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130	Identify as per dwg & Stock Location:	ST B	0.00
-----	---------------------------------------	------	------

130

Packaging Memo

Packaging

140	QC21- Final Inspection - Work Order Release	0.00
-----	---	------

140

QC Memo

Quality Control

212-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-21-12 1:39:06 PM

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Work Order ID: 81953

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Parent Item: D2652

D2652

Parent Item Name: Bushing

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP Rev:B02.06.13Now machined in house.NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased	No			100	f	263.2350	0.055	11.57895			

M303R0 500

303 Round Bar 0.500"

**

22 2.1.22

Location

Loc Qty

Loc Code

MAT028

263.235

117143

11.34

118271 ✓

11.9

118509

2.36

119009 ✓

140.088

119616

97.547

10.583

1.583

11.666

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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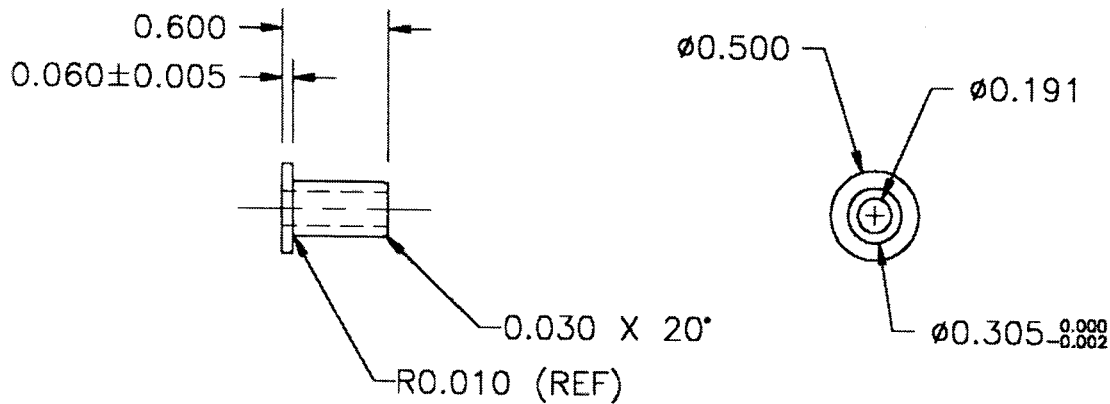
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

RELEASED
97/04/25 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81953
12/03/21

MATERIAL: AISI 303 SS
NOTE: BREAK ALL SHARP CORNERS 0.010 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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